

Work Order ID 53847

November 20, 2009 9:29:47 AM



Page 1

Item ID: D206-667-101

Revision ID: C

Item Name: Crosstube Fwd

Start Date: 11/19/09 Start Qty: 1.00

Required Date: 11/20/09 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: 

QC:

Date:

Tooling:

Date:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D206-667-141

Rev C

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels as per PPP D206-667-101 CHG003

8 on 12/03

10 for BG 09/11/20

250

0.00



Crosstubes

Crosstubes

Crosstubes

Memo

0.00

PULL FROM STOCK:
1 X D206-667-101 B35571 CHG002
REMOVE SUPPORTS, REINSTALL WITH MAGNABOND PER CHG 004
1-Install support using 0.03" to 0.06" thick layer of magnabond 6398 per QSI
015. Let cure for 12h after installation and prior to packaging. Note: (3) top
holes should be facing up.
A/R Magnabond 6398 : 112417 exp: 01/2011

2-Torque clamps to 80-100 in lb

ml 09.12.02 ①

3-Install nut plates as per Dwg D206-667-141. Touch-up rivet heads with Imron
paint.

N/A

PTO
~~Limit~~

ml 09 12 01 ①

DART

TRANSPORT CANADA APPROVAL # 09-89

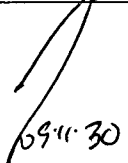
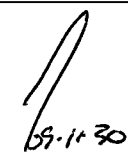

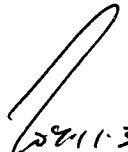
TEL.: 1-613-632-3336
FAX: 1-613-632-4443

P/N	D206-667-101	CHG	CHG002
DESC	Crosstube Fwd High	STC	SH01-5
LOT	B35571	STC	SR01304NY
MODEL	Bell 206A/B	STC	

MADE IN CANADA

W/O: 53847

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-11-30	250	Must Sand & Repaint, Due to previous sanding for abrasion strips (unable to buff out) as per QSI 005	MM	09-11-30	1	 09-11-30	 09-11-30
09-12-01	250	QC 14 inspect spray paint	EC	09-12-01	1	 09-11-30	 09-11-30

Part No: D206-667-101 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53847

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Page 2

Item ID: D206-667-101

Accept

Revision ID: C

Item Name: Crosstube Fwd

Start Date: 11/19/09 Start Qty: 1.00

Required Date: 11/20/09 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00

27 8 09/12/02

QC

Memo

0.00

Quality Control

270

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

ENSURE ORIGINAL KIT IS INCLUDED IN PACKAGING

280

QC4- 100% Inspect kits for completeness

0.00

27 8 01/12/03

QC

Memo

0.00

Quality Control

Work Order ID 53847

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Page 3

Item ID: D206-667-101

Accept

Revision ID: C

Item Name: Crosstube Fwd

Start Date: 11/19/09 Start Qty: 1.00

Required Date: 11/20/09 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

290

0.00



Packaging

Packaging

Memo

0.00

RE-PACKAGE USING NEW B/N
NEW LABELS AND PAPERWORK REQ'D

CHG003

300

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

Cust Item ID:

Customer:

09/12/30

09/12/07

09/12/03

Picklist Print

November 20, 2009 9:29:46 AM

Page 1

Work Order ID: 53847

Parent Item: D206-667-101RevC

Parent Item Name: Crosstube Fwd


Comments:

Start Date: 11/19/09

Required Date: 11/20/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D206-667-101RevC		Manufactured	No				Each	6.0000	1.0000			
												
Crosstube Fwd												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FG	3	
16409	0	
16411	0	
29101	1	
29258	1	
29263	1	
35571	1	
50094	1	
52050	1	

35571

~~DA760 SD~~

Clamp: MS21920-20 B: 112307 x4

Rubber Cushion: D3595-063-395 B: 44667 x4

mt 07 12 07

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. C
REF: CANADIAN STC: SH01-5
REF: FAA STC: SR01304NY

32847

For D206-667-101/-201/-103/-203 or D407-667-105 crosstubes at CHG 003 or later, the D2856-400-694/-773 abrasion strip has been removed, the center D2891-1 or D2892-1 support has been bonded onto the crosstube using Magnabond 6398 and D3595-063-395/-450 Rubber Cushions have been installed underneath the MS21920-20/-22 Clamps. Amend parts list of the IIN-D206-667 Section 5 and ICA-D206-667 Section 32.8 as follows:

REMOVE:

ITEM	QTY -101	QTY -201	QTY -103	QTY -203	QTY -105	PART NUMBER	DESCRIPTION
13	2	2	2		2	D2856-400-694	ABRASION STRIP
14				2		D2856-400-773	ABRASION STRIP

ADD:

ITEM	QTY -101	QTY -201	QTY -103	QTY -203	QTY -105	PART NUMBER	DESCRIPTION
24	4	4	4		4	D3595-063-395	RUBBER CUSHION
25				4		D3595-063-450	RUBBER CUSHION

To prevent the supports from shifting on the D206-667-101/-201/-103/-203 or D407-667-105 crosstubes at CHG 002 or earlier, the D2891-1/D2892-1 supports should be removed and re-installed as follows:


- Follow section 32.1 of ICA-D206-667 for the removal of the crosstubes from the helicopter.
- Remove the qty (2) MS21920-20/-22 clamps from the crosstube that fasten the D2891-1/D2892-1 supports to the crosstube.
- Remove the D2856-400-694/-773 abrasion strip from the crosstube per section 32.5 of ICA-D206-667.
- Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection of ICA-D206-667. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection in ICA-D206-667. Touch up finish per item 5.3.9 of the 300 hour inspection.
- Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- Apply a 0.03" to 0.06" thick layer of Magnabond 6398 underneath the D2891-1/D2892-1 support and re-install the support on the crosstube as shown in Figure 1. Position and secure the D2891-1/D2892-1 support on the crosstube using MS21920-20/-22 Clamps. Install a D3595-063-395/-450 Rubber cushion underneath each MS21920-20/-22 Clamp. Torque clamps 80-100 in-lb. Let the D206-667-101/-201/-103/-203 or D412-667-105 crosstube assembly cure as per the Magnabond 6398 instructions before re-installing the crosstube on the aircraft.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 08.11.06
CERT. NO.: SH01-5
ISSUE NO.: 3

B	D3595-063-395 WAS D3595-075-395; D3595-063-450 WAS D3595-075-450	RF	08.11.06
A	NEW ISSUE	HS	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9415	SHEET 1 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE NTS	
DATE	08.11.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

7) Re-install the D206-667-101/-201/-103/-203 or D412-667-105 crosstube per section 32.2 of ICA-D206-667.

For customers who would like to upgrade their D206-667-101/-201/-103/-203 or D412-667-105 crosstubes from CHG 002 or earlier to CHG 003, the following kit can be obtained from Dart:

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9415-011	CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-101/-201/-103 OR D407-667-105)
	X	DSI 9415-013	CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-203)
4		D3595-063-395	RUBBER CUSHION
	4	D3595-063-450	RUBBER CUSHION

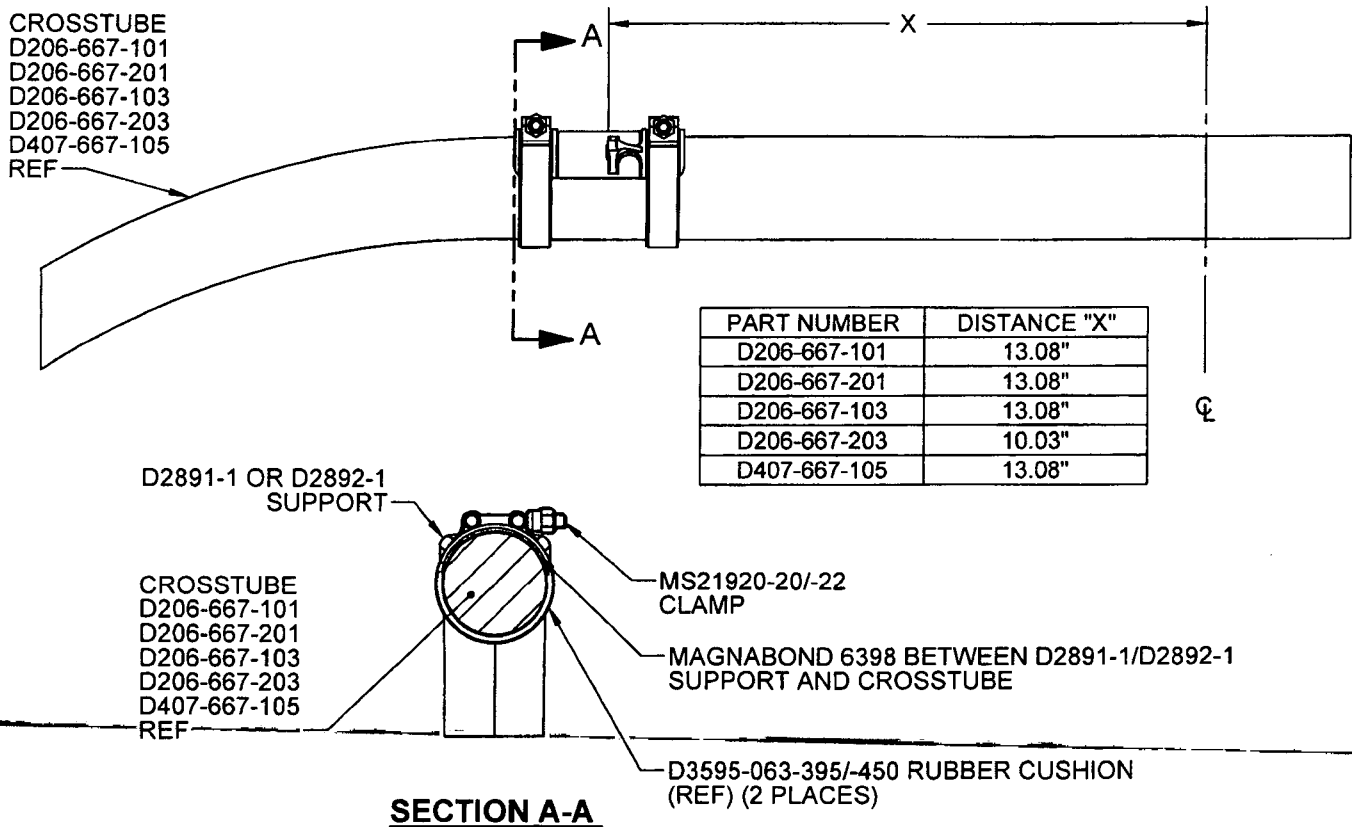


FIGURE 1 - CROSSTUBE SUPPORT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

DATE: 08.11.06
CERT. NO.: SH01-5
ISSUE NO.: 3

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9415	SHEET 2 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE	NTS
DATE	08.11.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Item	Qty -141	Part Number	Description
1	X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
2	1	D6001-105	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 93.18±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-141" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 11.3 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
02/11/12

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C4-3, C5-3 & D3-3); RELOCATED FLAG #5 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
1 A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-141	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
DE APPR.	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

8 7 6 5 4 3 2 1

12 D2891-1 SUPPORT
2 PL

15 MS21920-20 CLAMP
4 PL

13 D3595-063-395
RUBBER CUSHION
4 PL, (UNDER CLAMP)

B

13.08

B

A4-2

D206-667-501

B7-2

D2873-043
NUT PLATE

MS20601AD4W8
RIVET, 4 PL

D2873-045
NUT PLATE

MS20601AD4W8
RIVET, 3 PL

90° REF

C6-2 **VIEW A-A: CUFF DETAIL**
SCALE 4X

C

D206-667-141
ASSEMBLY DETAIL
(VIEW LOOKING FWD)

FWD

9°

13 15

MS21920-20 CLAMP REF

12

D2891-1 SUPPORT REF

C

D3595-063-395
RUBBER CUSHION REF

DS-2 **SECTION B-B**
SCALE 5X

67825
info

RELEASED
08/11/06

D2873-043
NUT PLATE

D2873-045
NUT PLATE

MS20601AD4W8
RIVET, 4 PL

MS20601AD4W8
RIVET, 3 PL

90° REF

C3-2 **VIEW C-C: CUFF DETAIL**
SCALE 4X

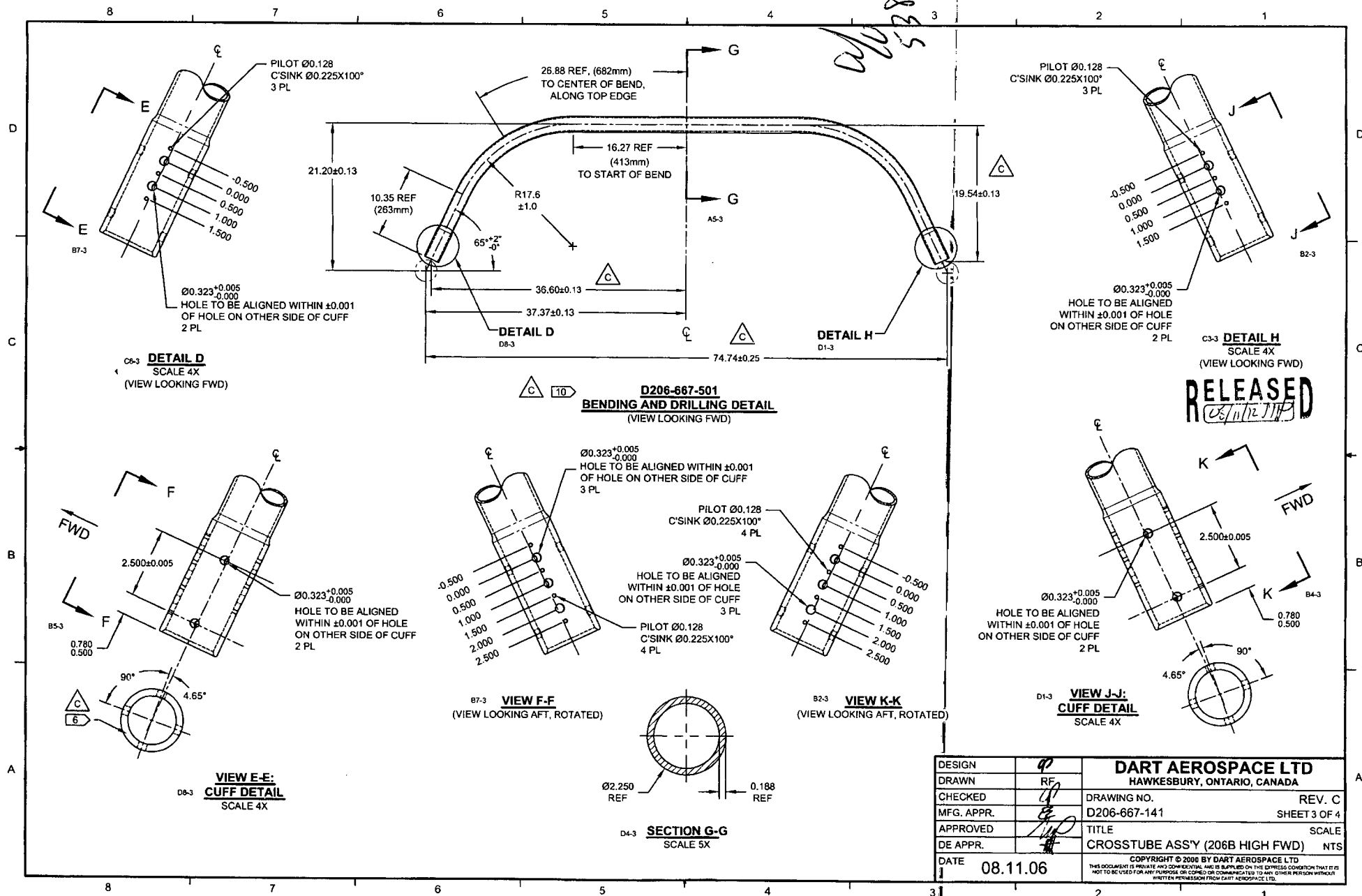
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CHECKED	18
MFG. APPR.	18
APPROVED	18
DE APPR.	18
DATE	08.11.06

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

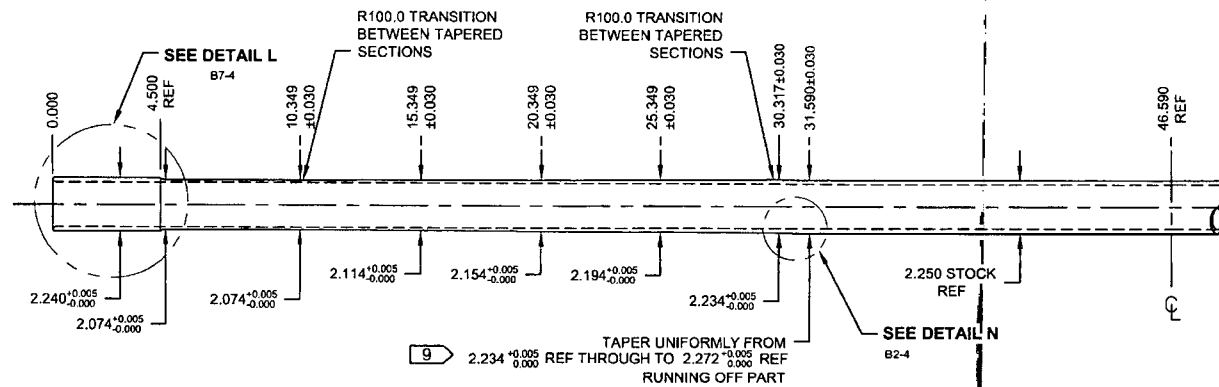
DRAWING NO.	REV. C
D206-667-141	SHEET 2 OF 4
TITLE	SCALE
CROSSTUBE ASS'Y (206B HIGH FWD)	NTS

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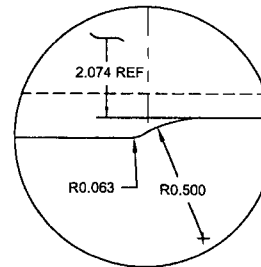
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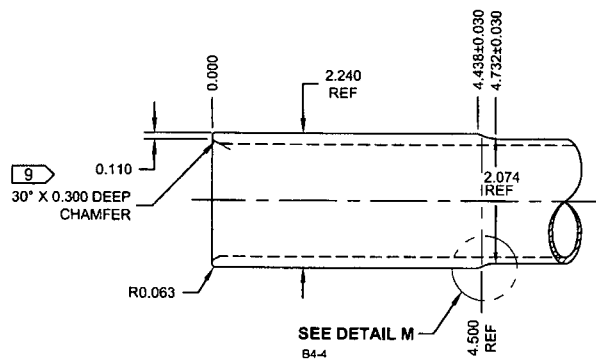
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	4	DRAWING NO. REV. C
MFG. APPR.	4	D206-667-141 SHEET 3 OF 4
APPROVED	4	TITLE SCALE
DE APPR.	4	CROSSTUBE ASS'Y (206B HIGH FWD) NTS
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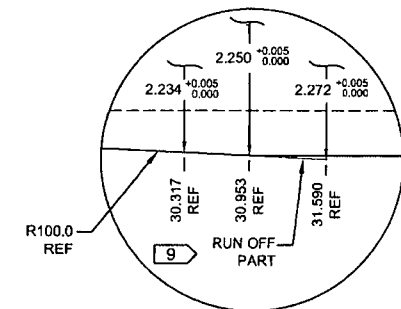
C TURNING DETAIL



**DETAIL M:
CUFF TRANSITION**
NOT TO SCALE



**DETAIL L:
CROSSTUBE CUFF**
NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
NOT TO SCALE

RELEASED
08/11/06

DESIGN	9	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	4	DRAWING NO. REV. C
MFG. APPR.	4	D206-667-141 SHEET 4 OF 4
APPROVED	4	TITLE SCALE
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5.0 PARTS LIST

Item	Qty -011	Qty -013	Qty -015	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X									D206-667-011	SPACER BLOCK KIT
		X								D206-667-013	NUT PLATE KIT (-101/-103/-105/-203/-205)
			X							D206-667-015	NUT PLATE KIT (-201)
				X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
					X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
						X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
							X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
								X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
									X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1				1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2					1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3						1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4							1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5								1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6									1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10				*2	*2	*2		*2		D2891-1	SUPPORT
11							*2			D2892-1	SUPPORT
12									*1	D2894-1	SUPPORT
13				*2	*2	*2		*2		D2856-400-694	ABRASION STRIP
14							*2		*2	D2856-400-773	ABRASION STRIP
15									*1	D2856-600-851	ABRASION STRIP
16				*4	*4	*4		*4		MS21920-20	CLAMP
17							*4		*4	MS21920-22	CLAMP
18									*2	MS21920-24	CLAMP
19				4	4	4		4		AN5-32A	BOLT
20							4		4	AN5-34A	BOLT
21				4	4	4	4	4	4	MS21042L5	NUT (OR MS21042-5)
22				8	8	8	8	8	8	AN960JD516	WASHER
23									*2	D3190-1	CHAFING SHIELD
30	8									AN4-6A	BOLT
31	8									AN4-7A	BOLT
32	16									AN960JD416	WASHER
33	2									D3193-041	SPACER BLOCK ASSEMBLY
40		2		*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41		2		*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42			2		2					D2872-043	NUT PLATE
43			2		2					D2872-045	NUT PLATE
44		10		10		10				AN5-7A	BOLT
45		10	10		10		10	10	10	AN5-10A	BOLT
46		4	4	4	10	4		4		AN5-30A	BOLT
47		4					4		4	AN5-32A	BOLT
48		18	18	10	12	10	10	10	10	AN960JD516	WASHER
49		4	4		6					MS21042L5	NUT (OR MS21042-5)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/241/143/243, & D407-667-145/245 ASSEMBLIES ABOVE

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